



Dart Aerospace Ltd.
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Canada

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D2012-105
Job Sheet 178649



DAS
21
9-30

Part No: D2012-105

Job Qty: 20 ea

Part Name: Arm (31.06)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/5/18

Job Tracking No:

Due Date: 6/15/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV E IPP Rev: 02.04.03 Added Inspect level 3 NG

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		6/15/18	0.00	0.00	Start Up Small Fab-4		SMB
100	Brake NC	20 pcs		6/15/18	0.00	5.67	Brake NC 2		SMB
110	Small Fab	20 pcs		6/15/18	0.00	3.68	Small Fab-1		SMB
120	QC	20 pcs		6/15/18	0.00	0.00	QC5		38
130	Powdercoat	20 pcs		6/15/18	0.00	0.71	Powdercoat4		38
140	QC	20 pcs		6/15/18	0.00	0.00	QC3		38
150	Packaging	20 pcs		6/15/18	0.00	0.00	Packaging3-1		38
160	QC21-SA	20 Ea		6/15/18	0.00	0.00	QC21		38

Part Op 100 - Punch to length as per Dwg D2012-105 & template D2012-105T1 and DT8116 Use DT10255 TO CHECK PART
Descriptions: 110 - 1-Deburr

120 - Use DT10255 TO CHECK PART

130 - START TIME: 9:20 OVEN TEMPERATURE: 300° FINISH TIME: 9:50 11/3870

32.150

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304TR0.500W.035	304 Round Tube .500 X .035W	52.5000 (2.6254 ea)	90-Start up Operation	S082251

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304TR0.500W.035	53	72	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Arm	31.190Inches ± 0.030	31.220 31.160		
2	Arm	31.060Inches ± 0.030	31.090 31.030		
3	Arm	0.257Inches + 0.006 - 0.001	0.263 0.256		

WORK ORDER NON-CONFORMANCE / UPDATE



DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order update only ☐

DISPOSITION

AGAINST DEPARTMENT/PROCESS

Drawwork ☐

Skid-tube ☐

Cross tube ☐
Small Fab ☐

Water Jet ☐
Prod. Eng. Coord. ☐

Manufacturing ☐

Engineering ☐
Quality ☐
Other ☐

Sus

Work Order: _____
Part No. _____
NCR No. _____

Date: _____ Step #: _____

Description Work Order Dev

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Date: 06/27/18



Container No: S084740

Part: D2012-105

Job No: 178649

Serial No/Batch: S084740

Revision: _____
Inspector: _____
Exp Date: _____
Instructions: _____

Completed By

Lead hand / Supervisor
Approval Verification

QC / QA Coordinator
Approval

Root Cause

Environment		No Re-verification		Pressure/Forced		Set-up		Positioned Wrong	
Design		Operator		Bending		BOM/Route		Outside Dimensions	
Doc/Data		Offset/Setup		Centre Not Concentric		Broken/Damage/Defect		Over/Under tolerance	
Equip/Tooling		Supplier		Cracks		Inspection Incomplete/Unqualified		Part Incorrect	
Handling/Pre		Training		Crimp/Kink/Ripple/Wave		Contamination		Part Lost/Missing	
Material		Use for Testing		Cuffs		Counter-sink		Part Moved	
Internal Transport		Poor Information		Crushing		Cut Too Short		Drawing	
Tribal Knowledge		Rushing		Heat Treat		Instructions Incomplete/Unclear		Finish	
LOA		Product Improvement		Wave/Twist in Tube		Drill Holes		Misread	
Substation		Process Improvement		Marks/Chatter				Turning Sequence	
Past Expiry Date		Manufacturing Process							
Misidentified		Past Due							

OTHER: _____